

Date: Monday, 10/16/2006 1:56:33 PM  
 User: Kim Johnston

## Process Sheet

*split*  
*SB 06/11/22*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT  
 Job Number : 28996  
 Estimate Number : 10200  
 P.O. Number : *N/A* Part Number : D21991  
 This Issue : 10/16/2006 S.O. No. : *N/A* Drawing Number : D2199 REV. E1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : E1  
 Previous Run : 28071 Material : *N/A*  
 Written By : Due Date : 10/30/2006 Qty: 6 Um: Each  
 Checked & Approved By : *JA 06/10/16*  
 Comment : Est B 02.06.10 Added finish NG/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 1.6275 f(s)/Unit Total : 9.7650 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall  
 (M304TR0750W049)

Batch No: *M101593*

*FF 06-11-22*

2.0 BRAKE NC NC BRAKE



Comment: BRAKE NC

Punch per Dwg. D2199 and Spec Control Dwg D2638

*FF 06-11-22*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

*FF 06-11-22*

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 06/11/22*

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*FC 06 11 22 (1)*

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FC 06/11/22 (1)*

2



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 28996

Part Number: D21991

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*26.11.22* (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)  
*26.11.22*

Job Completion



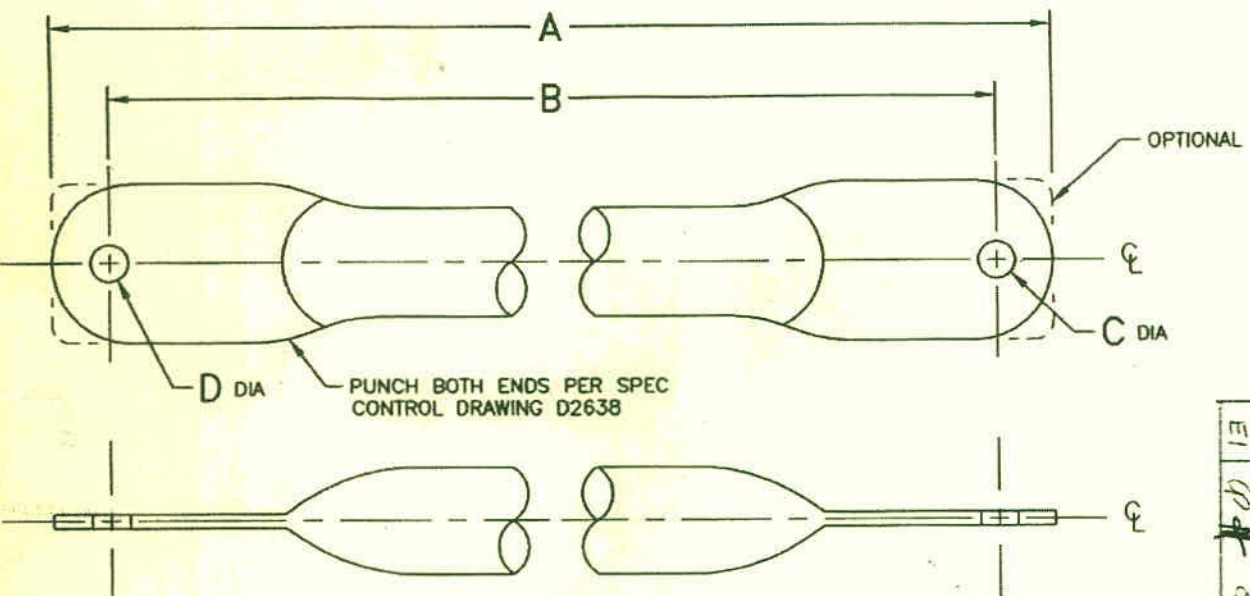
*26.11.22*





**DART****RELEASED**  
48.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2199	SHEET 1 OF 1
DATE 98.04.28		TITLE STRUT DETAILS	SCALE NTS
A	1993	NEW ISSUE	
B		ADDED -11, -13, AND -15	
C		ADDED -17 AND -19	
D		ADDED -21	
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
E1	98.05.22	ADD FINISH	



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B B B C C C E E

\* 00.10.13  
\* 00.10.13**NOTES:**

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER PART Q51 005 4.3/E1

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WORK ORDER  
NO. 28996

